

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029853**Date Inspected:** 24-Jun-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 930**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1800**Contractor:** XKT/Nesco**Location:** XKT Engineering, Vallejo**CWI Name:** Wayne Van de Wark**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Saddle Plate & annealing fixture**Summary of Items Observed:**

Caltrans Quality Assurance Inspector (QAI) Monty Morris arrived at the XKT/Nesco facility for the purpose of witnessing fabrications of S1 & S2 Shear Key retrofit. The QC Manager was contacted by this QAI regarding the E2 Shear Key fabrications. The inspections performed were in accordance with the Standard Specifications and the project Special Provisions

A 3" thick upper saddle plate identified as item S10A-c1 was preheated while in it's annealing fixture prior to being hydraulic-ram frame-pressed into the contours of same fixture. Intermittent fillet welding was performed by the welder Oscar Montana, ID #ZZ, joining the plate to it's annealing fixture utilizing a Lincoln Electric 'UltraCore' 1/16" diameter FCAW-G electrodes as per the Welding Procedure Specification (WPS) identified as XKTD15-00.

WELDING INSPECTION REPORT

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Summary of Conversations:

There were general conversations with Quality Control personnel at the start of the shift regarding the location of the work and inspection personnel scheduled for this shift.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By: Morris, Monty

Quality Assurance Inspector

Reviewed By: Foerder, Mike

QA Reviewer